



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5425-043
Job Sheet 196265



Part No: D5425-043

Job Qty: 1 pcs

Part Name: Float Skidtube Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/11/19

Job Tracking No:

Due Date: 7/30/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D5425 REV.B IPP REV:A 17.11.02 NEW ISSUE DD VERF:JFS IPP REV:B 18.08.20 AS PER DWG
REV.B DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1 pcs	7/30/19		0.00	8.24	Skidtubes - 1		TF
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
120	HAAS 4 Axis - B4B	1 pcs	7/30/19		1.00	22.77	HAAS - 1 - B4B		M.M. 2019/07/22
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
130	QC 2	1 pcs	7/30/19		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		

DAS
64
9-89



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S193260



Part: D5425-043

Job No: 196265

Serial No/Batch: S193260

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

Date: 06/24/19

Plex 6/11/19 7:22 AM Dart.lajeunesse.marie

6/11/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

DAS
64
9-89

2019/07/22

2019/07/22

TF

1/19 7:22

RL=../Part/J

140 QC 8

1
pcs

7/30/19

0.00 0.00

QC 2 - 49

QC 2 - 50

QC 2 - 51

QC 2 - 52

QC 2 - 57

QC 2 - 62

QC 2 - 63

QC 2 - 8

QC 2 - 66

QC 2 - 64

QC 2 - 65

QC 2 - 5

QC 2 - 71

QC 2 - 73

QC 2 - 69

QC 8 - 12

QC 8 - 14

QC 8 - 17

QC 8 - 20

QC 8 - 25

QC 8 - 3

QC 8 - 32

QC 8 - 33

QC 8 - 35

QC 8 - 39

QC 8 - 4

QC 8 - 44

QC 8 - 45

QC 8 - 49

QC 8 - 58

QC 8 - 8

QC 8 - 9

QC 8 - 68

QC 8 - 67

QC 8 - 1 (A)

QC 8 - 47

QC 8 - 40

QC 8 - 52

QC 8 - 23

QC 8 - 57

Handfinish - 1 - 1 -
B4BHandfinish - 1 - 2 -
B4BHandfinish - 1 - 3 -
B4BHandfinish - 1 - 4 -
B4BHandfinish - 1 - 5 -
B4BHandfinish - 1 - 6 -
B4BHandfinish - 1 - 7 -
B4BHandfinish - 1 - 8 -
B4BHandfinish - 1 - 9 -
B4BHandfinish - 1 - 10 -
B4B

Handfinish - 1 - 11 -

150 Handfinish - 1-1 Chemical-
B4B1
pcs

7/30/19

0.00 0.24

						B4B	
						Handfinish - 6 - 16 - B4B	
						Handfinish - 6 - 17 - B4B	
						Handfinish - 6 - 18 - B4B	
						Handfinish - 6 - 19 - B4B	
						Handfinish - 6 - 20 - B4B	
						Handfinish - 6 - 21 - B4B	
						Handfinish - 6 - 22 - B4B	
220 QC 7	1 pcs	7/30/19	0.00	0.00		QC 7 - 10	
						QC 7 - 13	
						QC 7 - 14	
						QC 7 - 15	
						QC 7 - 17	
						QC 7 - 18	
						QC 7 - 19	
						QC 7 - 2	
						QC 7 - 28	
						QC 7 - 3	
						QC 7 - 30	
						QC 7 - 34	
						QC 7 - 36	
						QC 7 - 37	
						QC 7 - 41	
						QC 7 - 47	
						QC 7 - 48	
						QC 7 - 51	
						QC 7 - 58	
						QC 7 - 59	
						QC 7 - 60	hva
						QC 7 - 9	
						QC 7 - 68	
						QC 7 - 50	
						QC 7 - 67	
						QC 7 - 40	
						QC 7 - 24	
						QC 7 - 43	
230 Skidtubes - 3 - B4B	1 pcs	7/30/19	0.00	8.24		Skidtubes - 1 - B4B	
						Skidtubes - 2 - B4B	
						Skidtubes - 3 - B4B	
						Skidtubes - 4 - B4B	TF
						Skidtubes - 5 - B4B	
						Skidtubes - 6 - B4B	
						Skidtubes - 7 - B4B	
240 QC 5	1 pcs	7/30/19	0.00	0.00		QC 5 - 10	
						QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	

						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	DAS SEP 06 2019 68
						QC 5 - 9	9-89
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
250 Handfinish - 6-2- Touch Up- B4B	1 pcs	7/30/19	0.00	0.33		Handfinish - 6 - 1 - B4B	
						Handfinish - 6 - 2 - B4B	
						Handfinish - 6 - 3 - B4B	SEP 09 2019
						Handfinish - 6 - 4 - B4B	
						Handfinish - 6 - 5 - B4B	
						Handfinish - 6 - 6 - B4B	
						Handfinish - 6 - 7 - B4B	
						Handfinish - 6 - 8 - B4B	
						Handfinish - 6 - 9 - B4B	
						Handfinish - 6 - 10 - B4B	
						Handfinish - 6 - 11 - B4B	
						Handfinish - 6 - 12 - B4B	
						Handfinish - 6 - 13 - B4B	
						Handfinish - 6 - 14 - B4B	
						Handfinish - 6 - 15 - B4B	
						Handfinish - 6 - 16 - B4B	
						Handfinish - 6 - 17 - B4B	
						Handfinish - 6 - 18 - B4B	
						Handfinish - 6 - 19 - B4B	
						Handfinish - 6 - 20 - B4B	
						Handfinish - 6 - 21 - B4B	
						Handfinish - 6 - 22 - B4B	
260 QC 7	1 pcs	7/30/19	0.00	0.00		QC 7 - 10	
						QC 7 - 13	
						QC 7 - 14	
						QC 7 - 15	
						QC 7 - 17	
						QC 7 - 18	
						QC 7 - 19	
						QC 7 - 2	
						QC 7 - 28	
						QC 7 - 3	
						QC 7 - 30	
						QC 7 - 34	

					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	AL 19-9-9
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
270	Spray Paint - 2 - B4B	1	7/30/19	0.00 0.50	Spray Paint - 1 - B4B	AL 19-9-9
	pcs				Spray Paint - 2 - B4B	
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
280	QC 14	1	7/30/19	0.00 0.00	QC 14 - 15	
	pcs				QC 14 - 2	
					QC 14 - 34	
					QC 14 - 41	
					QC 14 - 51	
					QC 14 - 58	
					QC 14 - 59	BEB 19-09-10
					QC 14 - 9	
					QC 14 - 68	
					QC 14 - 40	
					QC 14 - 19	
					QC 14 - 43	
					QC 14 - 24	
282	Outsource - 11 - Paint	1	7/30/19		ATE003-VC	2 N/R
	pcs					
284	Packaging 2-1 - Recelve - B4B	1	7/30/19	0.00 0.00	Packaging 2 - 1 - B4B	
	pcs				Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	

Paint done
in house
See Op #270

DAS
70
9-89

DAS
59
0-00

						Packaging 2 - 25 - B4B	
						Packaging 2 - 26 - B4B	
						Packaging 2 - 27 - B4B	
						Packaging 2 - 28 - B4B	
						Packaging 2 - 29 - B4B	
						Packaging 2 - 30 - B4B	
						Packaging 2 - 31 - B4B	
						Packaging 2 - 32 - B4B	
						Packaging 2 - 33 - B4B	
						Packaging 2 - 34 - B4B	
						Packaging 2 - 35 - B4B	
						Packaging 2 - 36 - B4B	
286 QC 6	1	7/30/19	0.00	0.00	pcs	QC 6 - 9	
						QC 6 - 68	N/R
						QC 6 - 61	
						QC 6 - 40	
290 Handfinish - 4-1-Assembly-B4B	1	7/30/19	0.00	0.24	pcs	Handfinish - 4 - 1 - B4B	
						Handfinish - 4 - 10 - B4B	BEB 19-09
						Handfinish - 4 - 11 - B4B	
						Handfinish - 4 - 12 - B4B	
						Handfinish - 4 - 13 - B4B	
						Handfinish - 4 - 14 - B4B	
						Handfinish - 4 - 15 - B4B	
						Handfinish - 4 - 2 - B4B	
						Handfinish - 4 - 3 - B4B	
						Handfinish - 4 - 4 - B4B	
						Handfinish - 4 - 5 - B4B	
						Handfinish - 4 - 6 - B4B	
						Handfinish - 4 - 7 - B4B	
						Handfinish - 4 - 8 - B4B	
						Handfinish - 4 - 9 - B4B	
300 QC 5	1	7/30/19	0.00	0.00	pcs	QC 5 - 10	
						QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	

Fg dock

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QSI005 4.2.2.4 PAINT BATCH: 5204428

280 - (QC14- Inspect Spray Paint)

282 - ***PLUG ALL CROSSBOLT SPACER HOLES PRIOR TO PRIME AND PAINT*** 1-PRIME AS PER DWG AND

QSI005 4.2.1.3.3 PRIMER BATCH: _____ 2-PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT BATCH: _____

284 - C OF C IS REQUIRED

290 - (Assemble as per dwg) 1-Install FWD and AFT cap seal with sikaflex-241 / 291 B _____ Exp; _____

Start time: _____ Finish time: _____ 2-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser. A/R LPS Procyon B _____

300 - (QC5- Inspect part completeness to step on W/O)

310 - (Identify as per dwg & Stock Location: _____)

320 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6028-195	Crosstube Material, 7075-T73/T73511	1 pcs (1 ea)	110-Skidtubes - 1	<u>5187596</u>
D5518-1	Crossbolt Spacer	18 pcs (18 ea)	230-Skidtubes - 3 - B4B	
D5512-1	Crossbolt Spacer	12 pcs (12 ea)	230-Skidtubes - 3 - B4B	
AN3C5A	Bolt	6 Ea (6 ea)	290-Handfinish - 4-1-Assembly-B4B	<u>5207570</u>
D3672-1	Washer, Phenolic	6 pcs (6 ea)	290-Handfinish - 4-1-Assembly-B4B	<u>F169008</u>
D5483-041	Tow Cap Assembly	1 pcs (1 ea)	290-Handfinish - 4-1-Assembly-B4B	<u>5199399</u>
D5484-041	Aft Cap Assembly	1 pcs (1 ea)	290-Handfinish - 4-1-Assembly-B4B	<u>5200349</u>
NAS1149C0332R	Washer	6 Ea (6 ea)	290-Handfinish - 4-1-Assembly-B4B	<u>5193136</u>

M.U. 011821

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D6028-195	1	15	0
230-Skidtubes - 3 - B4B	D5512-1	12	118	0
	D5518-1	18	236	0
290-Handfinish - 4-1-Assembly-B4B	AN3C5A	6	1,084	0
	D3672-1	6	1,669	0
	D5483-041	1	10	0
	D5484-041	1	9	0
	NAS1149C0332R	6	2,780	0

Part Specifications

Specifications could not be found.

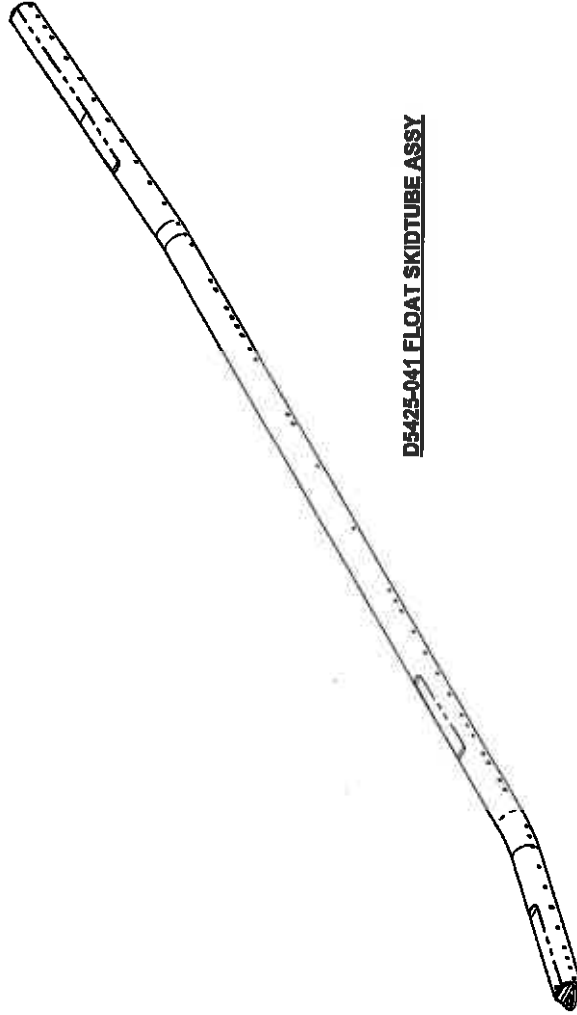
Plex 6/11/19 7:22 AM Dart.lajeunesse.marie

→ 5011757 x2 pcs
5187624 x6 pcs
5029722 x4 pcs

→ 5039301 x3 pcs
5183903 x14 pcs
5148264 x1 pcs

QTY -041	PIN	DESCRIPTION
X	D5425-041	FLOAT SKIDTUBE ASSY
6	D3672-1	WASHER
1	D5425-1	FLOAT SKIDTUBE
1	D5483-041	TOW CAP ASSY
1	D5484-041	AFT CAP ASSY
12	D5512-1	CROSSBOLT SPACER
37	D5518-1	CROSSBOLT SPACER
6	AN8C5A	BOLT
6	NAS1149C0332R	WASHER

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SUBJECT TO AMENDMENT 1
WITHOUT NOTICE
WORK ORDER
NO. 196265 MJS
1906-11



D5425-041 FLOAT SKIDTUBE ASSY

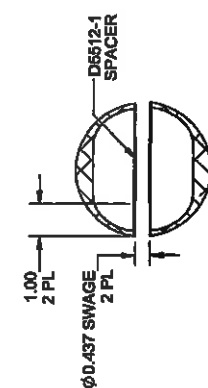
RELEASED
2018 AUG 16
E.N. 16-116

B	CHANGE HOLE SIZE TO IMPROVE OFF-AXIS SWAGING IN HOLE SIZE (HOLE SIZE 1/4" (6.35mm) PICTORIAL UPDATE DUE TO CHANGES IN D5425-1	NO	18.02.05
A	NEW ISSUE	NO	17.07.19
REV.	DESCRIPTION	BY	DATE
DESIGN	NO		
DRAWN	NO		
CHECKED	ZF		
MFG. APPR.	DD		
APPROVED	NO		
DIE APPR.	DS-1		
DATE	18.02.05		

DART AEROSPACE USA, INC. ELUGINE, OR		REV. B
DRAWING NO. D5425	SHEET 1 OF 10	SCALE
TITLE 412 FLOAT SKIDTUBE		NTS
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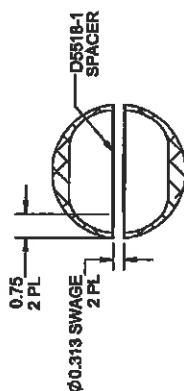
APPROVED

A schematic diagram of a D6425-1 Float Skid Tube. The tube is a long, narrow, slightly curved structure with a series of small circles (floats) along its length. It is shown in a vertical orientation. At the top, there is a circular component labeled 'D'. At the bottom, there is a circular component labeled 'A'. Two upward-pointing arrows labeled 'C' are positioned near the top, and two downward-pointing arrows labeled 'B' are positioned near the bottom. A label 'D6425-1 FLOAT SKID TUBE' with a leader line points to the main body of the tube.



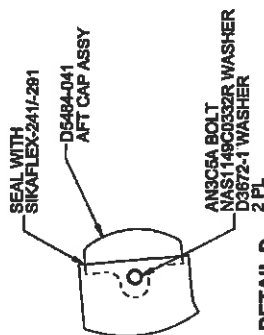
AFTER DRILLING AND BENDING, PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

- 1. WET INSTALL D5512-1 SPACER PER QSI 002**
- 2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002**
- 3. TRIM / GRIND FLUSH PER QSI 002**



AFTER DRILLING AND BENDING, PERFORM THE FOLLOWING FOR Ø0.377 HOLES ONLY:

- 1. INSERT D5518-1 SPACER**
- 2. SWAGE TO Ø0.313 X 0.75 DEEP PER QSI 002**
- 3. TRIM / GRIND FLUSH PER QSI 002**



DETAIL D
SCALE 4X

SECTION C-C
SCALE 4X
12 PL.

SECTION B-B
SCALE 4X
37 PL

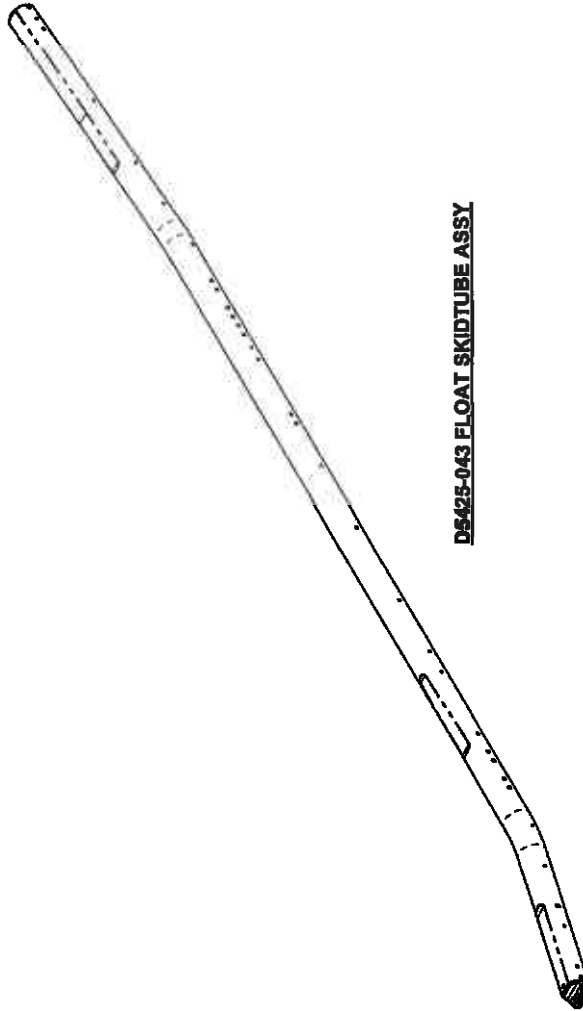
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2018 AUG 16

NOTES:
(1) MATERIAL: N/A
(2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME PER DART QSI 005 4.2.1,3.3
PAINT PER DART QSI 005 4.2.2,4
(3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
(4) UNITS: INCHES UNLESS OTHERWISE NOTED
(5) BREAK SHARP EDGES: N/A
(6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
(7) WEIGHT: 64.5lbs
(8) COAT ALL EXPOSED FASTENERS WITH LPS "LPS PROCYON"

DESIGN	NO	DART AEROSPACE USA, INC.	
DRAWN	NO	EUGENE, OR	
CHECKED	ZF	DRAWING NO.	REV. B
INFS. APPR.	DD	D5425	SHEET 2 OF 10
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	412 FLOAT SKIDTUBE	NITS
DATE	18.02.05	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED IT MAY BE USED FOR ANY PURPOSE AND BY ANY INDIVIDUALS WITHOUT PERMISSION OF DART AEROSPACE USA, INC.	

1 2 3 4 5 6 7 8

QTY	PIN	DESCRIPTION
X	D5425-043	FLOAT SKIDTUBE ASSY
6	D3672-1	WASHER
1	D5425-3	FLOAT SKIDTUBE (DART TRIBAG)
1	D5483-041	TOW CAP ASSY
1	D5484-041	AFT CAP ASSY
12	D5612-1	CROSSBOLT SPACER
18	D5618-1	CROSSBOLT SPACER
6	AN302A	BOLT
6	NAS1148C0332R	WASHER



D5425-043 FLOAT SKIDTUBE ASSY

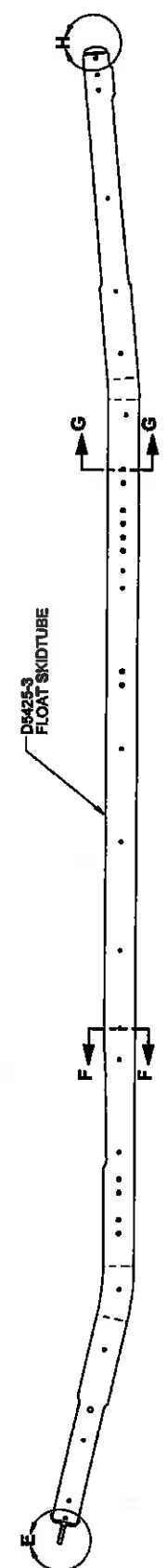
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2018 AUG 16 *4*

DESIGN	NO	NO	DART AEROSPACE USA, INC.	
DRAWN	NO	NO	EUGENE, OR	
CHECKED	ZF	NO	DRAWING NO.	REV. B
MFG. APPR.	DD	NO	D5425	SHEET 3 OF 10
APPROVED	NO	NO	TITLE	SCALE
DE APPR.	D5425	NO	412 FLOAT SKIDTUBE	NTS
DATE	18.02.05	NO		

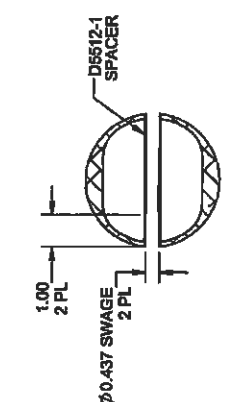
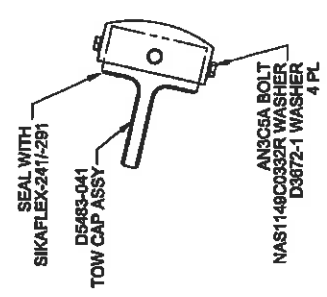
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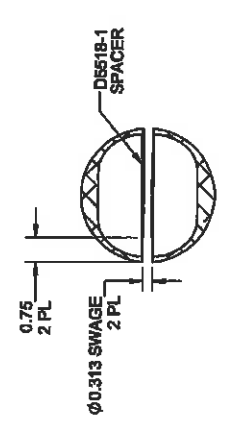
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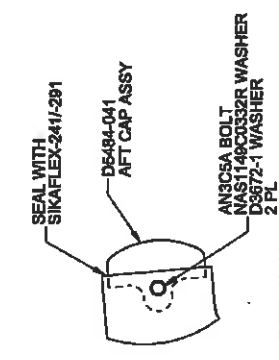
D5425-043 FLOAT SKIDTUBE ASSY



AFTER DRILLING AND BENDING, PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. WET INSTALL D5512-1 SPACER PER QSI 002
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002



AFTER DRILLING AND BENDING, PERFORM THE FOLLOWING FOR Ø0.377 HOLES ONLY:
1. INSERT D5518-1 SPACER
2. SWAGE TO Ø0.313 X 0.75 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002



DETAIL E
SCALE 4X

SECTION G-G
SCALE 4X
12 PL

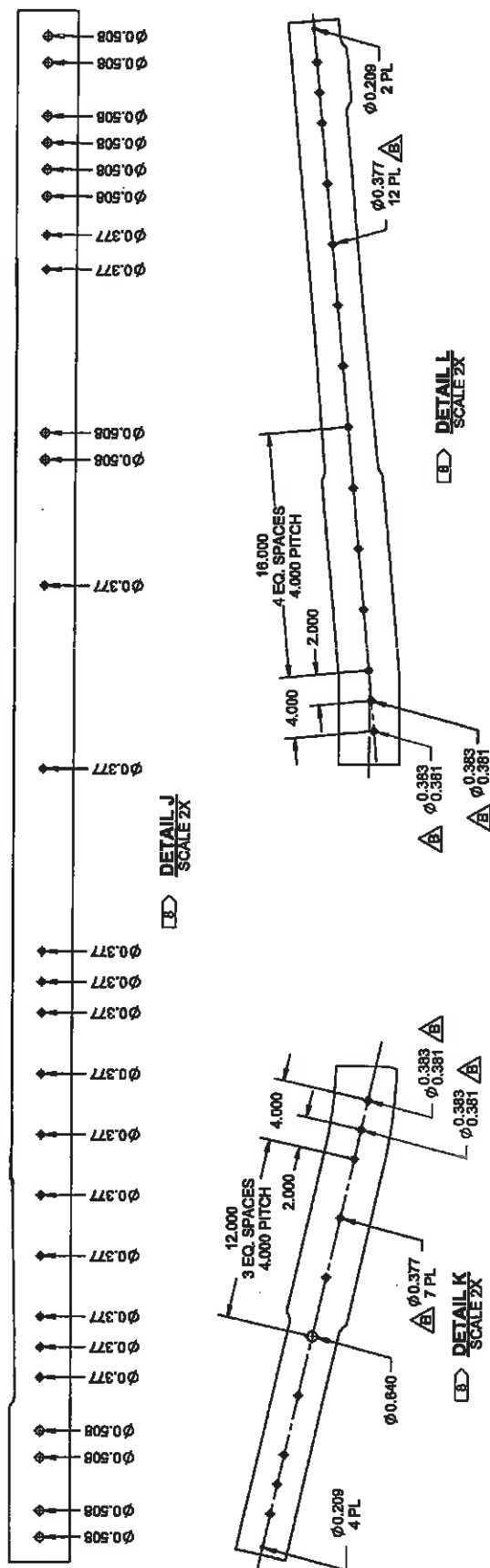
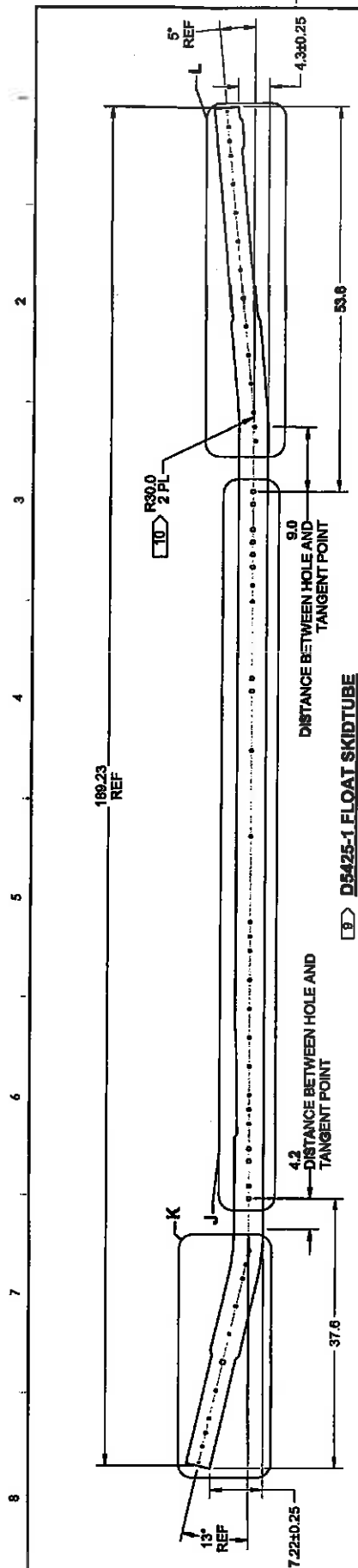
SECTION F-F
SCALE 4X
18 PL

RELEASED
2018 AUG 16

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME PER DART QSI 005 4.2.1.3.3
PAINT PER DART QSI 005 4.2.2.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES N/A
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 64.3lbs
 - 8) COAT ALL EXPOSED FASTENERS WITH LPS "LPS PROCYON"

DESIGN	NO	NO	DART AEROSPACE USA, INC.
DRAWN	NO	NO	EUGENE, OR
CHECKED	ZF	DRAWING NO.	REV. B
MFG. APPR.	DD	D5425	SHEET 4 OF 10
APPROVED	NO	NO	SCALE
DE APPR.	D5425	NO	412 FLOAT SKIDTUBE
DATE	18.02.05	DATE	NTS

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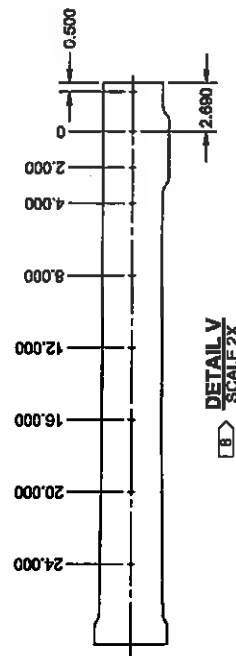
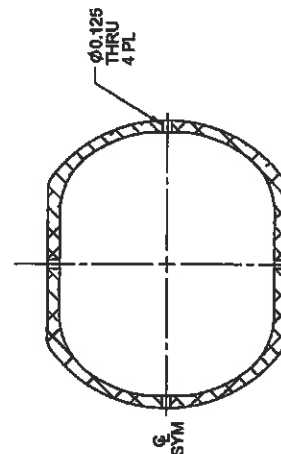
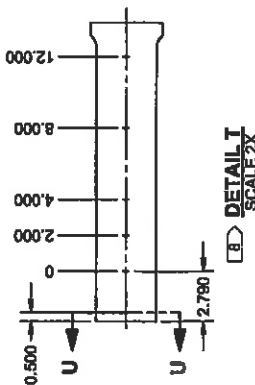
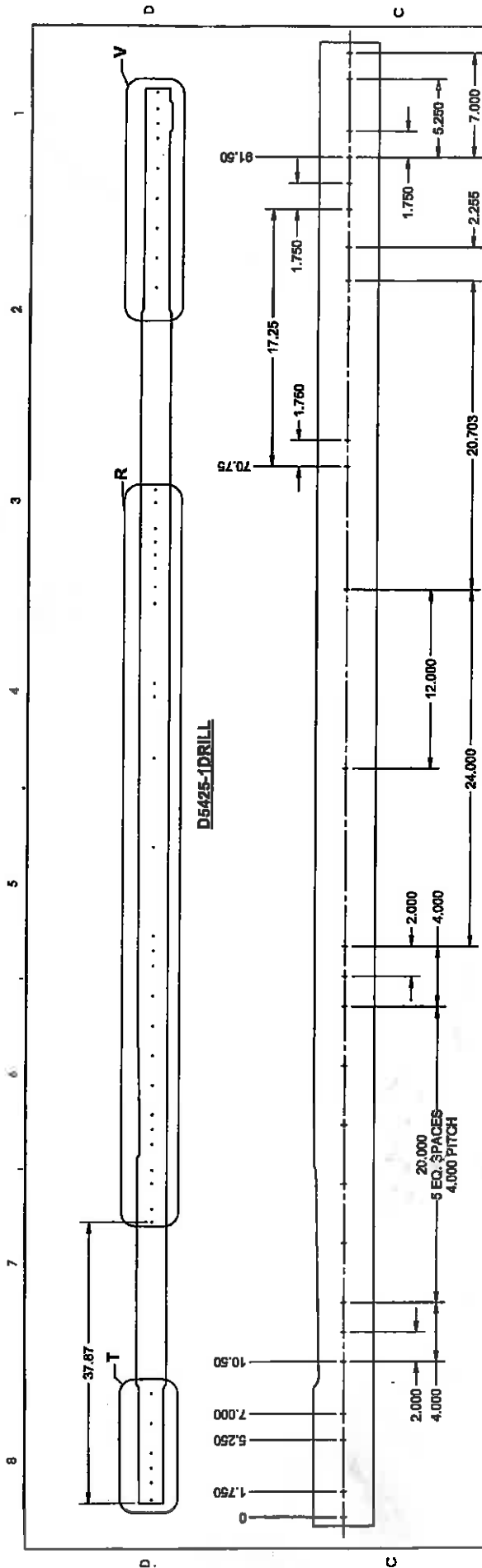


NOTES:

- 1 MATERIAL: MAKE FROM D5425-1DRILL
2 FINISH: NONE
3 TOLERANCES: PER DART QSI 0118 UNLESS OTHERWISE NOTED
4 UNITS: INCHES UNLESS OTHERWISE NOTED
5 BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6 IDENTIFICATION: NONE
7 WEIGHT: 52.57 lbs
8 ALL CENTERLINE HOLES THRU, BOTH SIDES AND ALIGNED WITHIN 0.010
9 MAXIMUM TWIST ALLOWANCE 3° BETWEEN FWD AND AFT BEND, 3° FROM
10 MAXIMUM 5% CRUSHING PER QSI 038 7.1

RELEASED
2018 AUG 16 *af*

DESIGN	NO	DART AEROSPACE USA, INC.	
DRAWN	NO	EUGENE, OR	
CHECKED	2F	DRAWING NO.	
MFG. APPR.	DD	D5425	
APPROVED	NO	REV. B	
DATE	18.02.05	SHEET 5 OF 10	
		SCALE	
		NTS	
		412 FLOAT SKIDTUBE	
		TITLE	
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NOTES:

- (1) MATERIAL: MAKE FROM D5425-MACH
- (2) FINISH: NONE; PER PART QSI 018 UNLESS OTHERWISE NOTED
- (3) UNITS: INCHES UNLESS OTHERWISE NOTED
- (4) IDENTIFICATION: NONE
- (5) IDENTIFICATION: NONE
- (6) WEIGHT: 52.57 lbs
- (7) ALL CENTERLINE HOLES ϕ 0.125 THRU, BOTH SIDES AND ALIGNED WITHIN 0.010.
- (8) MAINTAIN 0.005 TOLERANCE TO ALL SYMMETRY AND CENTER LINES PER QSI 018

2018 AUG 16 *10*
RELEASED

SECTION U-U
SCALE 4X

DESIGN	NO
DRAWN	NO
CHECKED	ZF
MFG. APPR.	DD
APPROVED	NO
DATE	DEC-86

DART AEROSPACE USA, INC.
EUGENE, OR

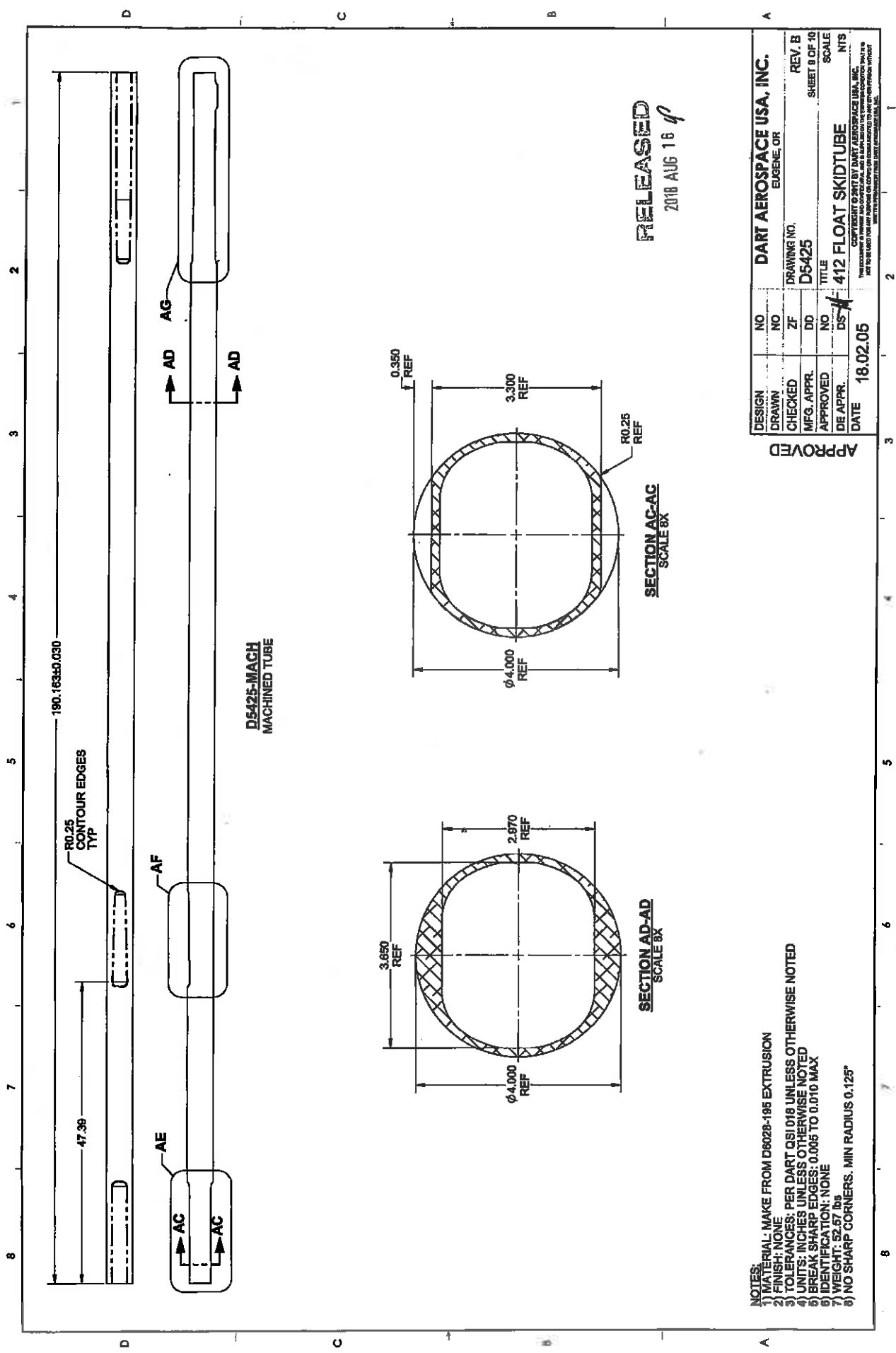
REV. 1
SHEET 7 OF 10
SC 1

WING NO. 425

2 FLOAT SKIDTUBE

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2018 AUG 16 *q*

DESIGN				DART AEROSPACE USA, INC.			
DRAWN	NO	NO	NO	EUGENE, OR			
CHECKED	ZF	DD	DD	DRAWING NO. D5425			
MFG. APPR.	NO	NO	NO	REV. B SHEET 8 OF 10			
APPROVED	NO	NO	NO	TITLE 412 FLOAT SKIDTUBE			
DIE APPR.	NO	NO	NO	SCALE NTS			
DATE	18.02.05	18.02.05	18.02.05	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC.			

APPROVED

- NOTES:
- 1) MATERIAL: MAKE FROM D6028-185 EXTRUSION
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART DSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 52.57 LBS
 - 8) NO SHARP CORNERS. MIN RADIUS 0.125"



RELEASED
2010 AUG 16 4

DESIGN	NO	DART AEROSPACE USA, INC.	
DRAWN	NO	EUGENE, OR	
CHECKED	ZF	DRAWING NO.	REV. B
MFG. APPR.	DD	D5425	SHEET 10 OF 10
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	412 FLOAT SKIDTUBE	NTS
DATE	18.02.05	COPYRIGHT © DART AEROSPACE USA, INC.	

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APPROVED

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ Scrap ☐ ☐ Use-as-is ☐ ☐		DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ ☐ ☐ Machining ☐ ☐ ☐ ☐ ☐ Large Fab ☐ ☐ ☐ ☐ ☐		Cross tube ☐ ☐ ☐ ☐ ☐ Small Fab ☐ ☐ ☐ ☐ ☐ Finishing ☐ ☐ ☐ ☐ ☐		Eng. (Non-AW) ☐ ☐ ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ ☐ ☐		Engineering ☐ ☐ ☐ ☐ ☐ Water Jet ☐ ☐ ☐ ☐ ☐ Supplier ☐ ☐ ☐ ☐ ☐ Quality ☐ ☐ ☐ ☐ ☐	
Date: _____		Sequence #: _____		QTY Affected: _____		MRB (QS1042)					
Description Work Order Deviation				Disposition							
Completed By				Lead hand / Supervisor				QC / QA Coordinator			

Root Cause Operator ☐ ☐ ☐ ☐ ☐ Manufacturing Process ☐ ☐ ☐ ☐ ☐ Equip/Tooling ☐ ☐ ☐ ☐ ☐ Handling/Preservation ☐ ☐ ☐ ☐ ☐ Material ☐ ☐ ☐ ☐ ☐ Product Improvement ☐ ☐ ☐ ☐ ☐ Process Improvement ☐ ☐ ☐ ☐ ☐ Human Factors ☐ ☐ ☐ ☐ ☐		FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table>										Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up	
Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong																																				
Bending	Misaligned/off center	Folio/Program	Outside Tolerance																																				
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Marks/Chatter	Drill Holes	Out of Sequence	Misread																																				
Mislabeled	Fit/Function	Off-set/Set-up																																					
Other/Details: _____																																							

DART AEROSPACE LTD		Work Order:
Description: 412 FLOAT SKIDTUBE		Part Number: D5425-3
Inspection Dwg: D5425 Rev: B		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.500	+/- .010	1.502	✓		vernier	
2.790	+/- .010	2.791	✓		vernier	
10.790	+/- .010	10.796	✓		vernier	
14.790	+/- .010	14.790	✓		tape	
43.120	+/- .010	43.125	✓			
44.870	+/- .010	44.875	✓			
48.37	+/- .010	48.375	✓			
60.37	+/- .010	60.375	✓			
64.37	+/- .010	64.375	✓			
74.37	+/- .010	74.378	✓			
123.328	+/- .010	123.325	✓			
125.87	+/- .010	125.875	✓			
129.37	+/- .010	129.375	✓			
131.12	+/- .010	131.125	✓			
134.62	+/- .010	134.625	✓			
136.37	+/- .010	136.375	✓		tape	
0.500	+/- .010	0.500	✓		vernier	
2.690	+/- .010	2.694	✓		vernier	
4.69	+/- .010	4.698	✓		vernier	
18.69	+/- .010	18.687	✓		tape	
15.24	+/- .030	15.240	✓		tape	
R1.0	+/- .100	R1.0	✓		Gaborit	
0.350	+ .000/- .020	.340	✓		pl/pur	
0.350	+ .000/- .020	.340	✓		pl/pur	
R1.0	+/- .100	R1.0	✓		Gaborit	
13.71	+/- .030	13.71	✓		tape	
0.152	+/- .015	.145	✓		pl/pur	
0.250	+/- .015	.240	✓		pl/pur	
9.35	+/- .030	9.350	✓		tape	
0.350	+ .000/- .020	.341	✓		pl/pur	
20.00	+/- .030	20.00	✓		tape	
0.250	+/- .005	.241	✓		pl/pur	

Measured by: 64	Checked by: [Signature]	QC Inspector:
Date: 20/07/22	Date: 19/07/22	Date:

Engineering Approval: (if necessary)	Date:
--	--------------

Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

